

Work Order ID 144103

April 01, 2016 3:41:40 PM

144103

Page 1

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 5/2/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/13/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SLT 12016040 Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	C								
D4020	A								

100

100

Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 132613 0.00
 Large Fab

Memo 0.05

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

APR 19 2016

DAS
24
9-00

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo 0.00

① 16-04-29 2D

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

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Revision ID: Stop *NS2*

Item Name: Long Basket Lid Assembly (350)

Start Date: 5/2/2016 Start Qty: 1.00 *1*

Required Date: 5/13/2016 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							① 16-04-29 PD
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							1 ① 16-04-29 333
Powder Coating	*** mask sides of hinge prior to powdercoat*** Start Time: 8:00 Oven Temperature: 320° Finish Time: 8:30								
140	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
140									
HandFinish	Memo	0.01							12 ① 16/04/29
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***								

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				/			DAS 38 9-89 MAY 02 2016
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>w/o</u> Memo	0.00 0.00			D 4272-012 / B143871	12	q	16/05/02	
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				ML5			MAY 02 2016 2m 16/05/02

DQA: _____ Date: _____



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Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐				

Picklist Print

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Page 1

Work Order ID: 144103

144103

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/2/2016

Required Date: 5/13/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS
PER DWG REV.pc1 DD VERF:JLM IPP REV:D 13.06.21 DWG
REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3914-1 *D3914-1* Rib		Manufactured	No			100	Each	4.0000	2	2		APR 18 2016	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				4					
				142379				4		2			
D3914-7 *D3914-7* Rib		Manufactured	No			100	Each	4.0000	2	2		APR 18 2016	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				4					
				142380				4		2			
D4018-5 *D4018-5* Rib		Manufactured	No			100	Each	21.0000	9	9		APR 18 2016	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				21					
				141367				3					
				142376				18		9			
D4035-043 *D4035-043* Lid Rib Assembly, Aft (350 Basket)		Manufactured	No			100	Each	4.0000	2	2		APR 18 2016	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				4					
				142373				4		2			

Picklist Print

Page 2

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Work Order ID: 144103

144103

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/2/2016

Required Date: 5/13/2016

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No

100 Each

20.0000

2

2

DAS

D2581

Mounting Bracket

**

APR 18 2016

24
9-89

Location

Loc Qty

Loc Code

WA004

20

132771

1

136270

2

139082

17

2

D2728-3 Manufactured Yes

140 Each

0.0000

1

1

D2728-3

Dart Logo Label Large

**

D4016-3

Manufactured No

100 Each

70.0000

3

3

DAS

D4016-3

Hinge Half, Lid

**

APR 18 2016

24
9-89

Location

Loc Qty

Loc Code

WA004

70

140701

13

140746

57

3

D4020-5 Manufactured No

100 Each

0.0000

1

1

D4020-5

Mesh (350 Basket Long, Lid)

**

B144256 → L APR 18 2016

DAS
24
9-89

D4021-3

Manufactured No

100 Each

21.0000

1

1

DAS

D4021-3

Data Plate

**

APR 18 2016

24
9-89

Location

Loc Qty

Loc Code

WA004

21

140814

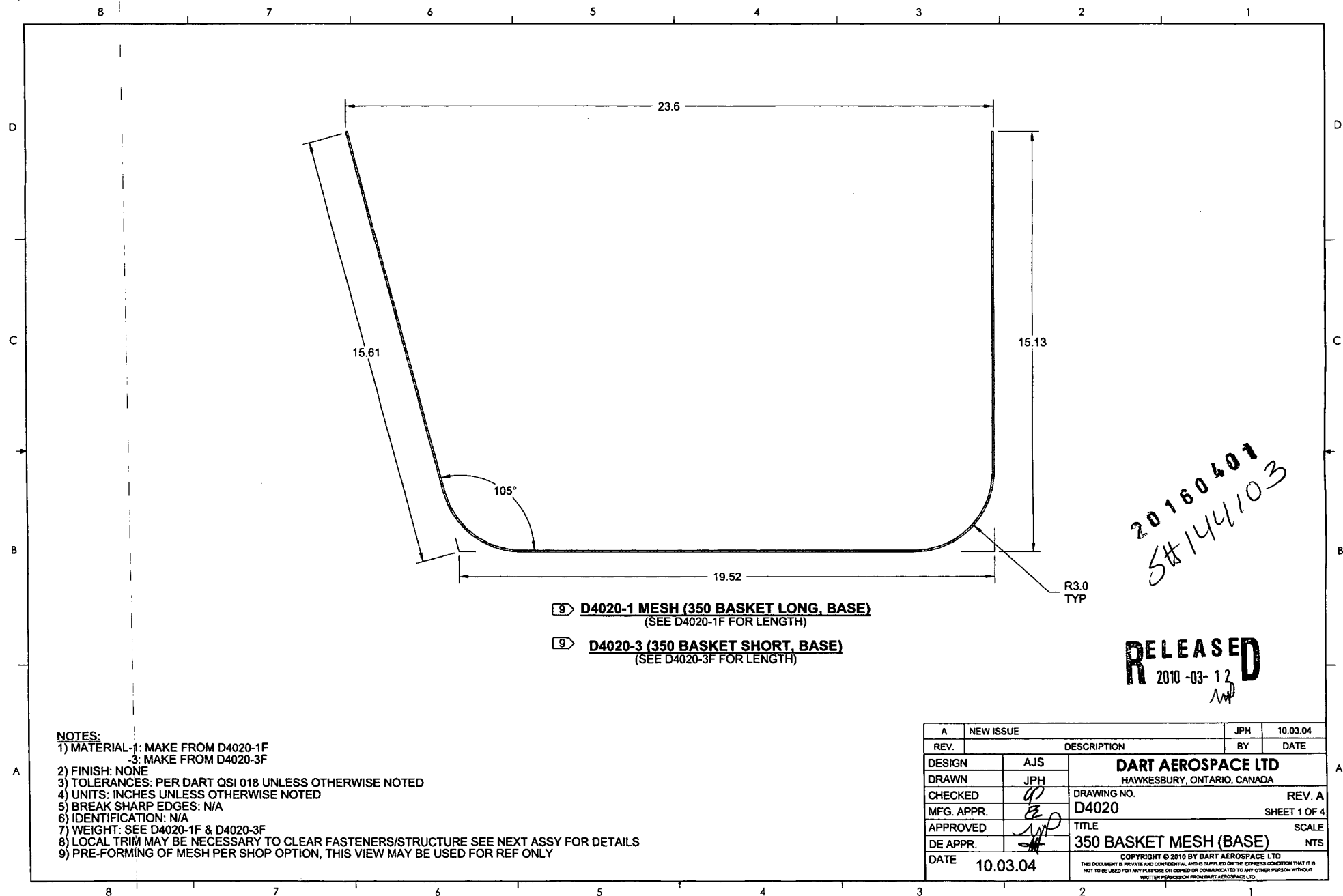
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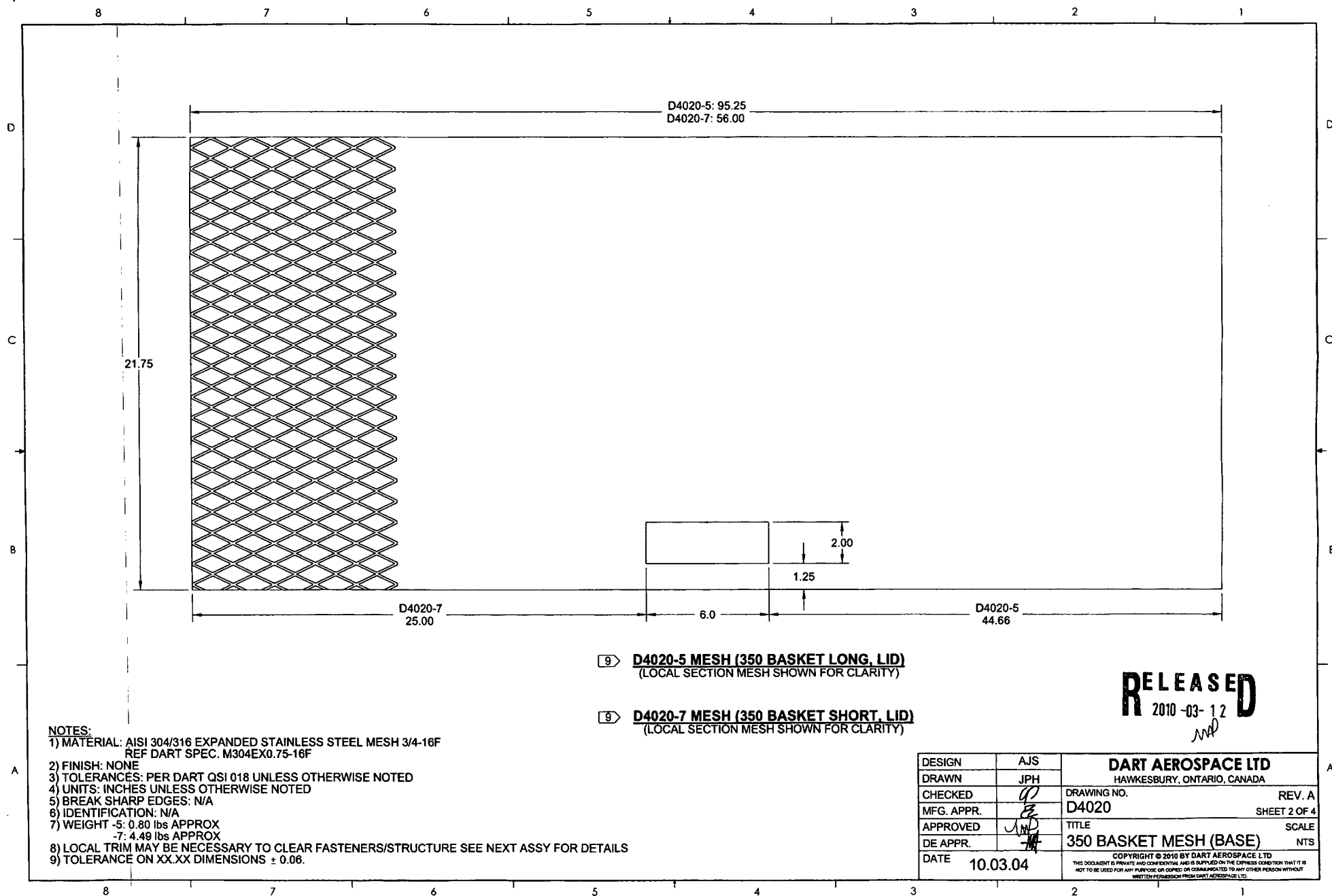
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April 01, 2016 3:41:44 PM

Shop Packet Print

Page 2





NOTES:

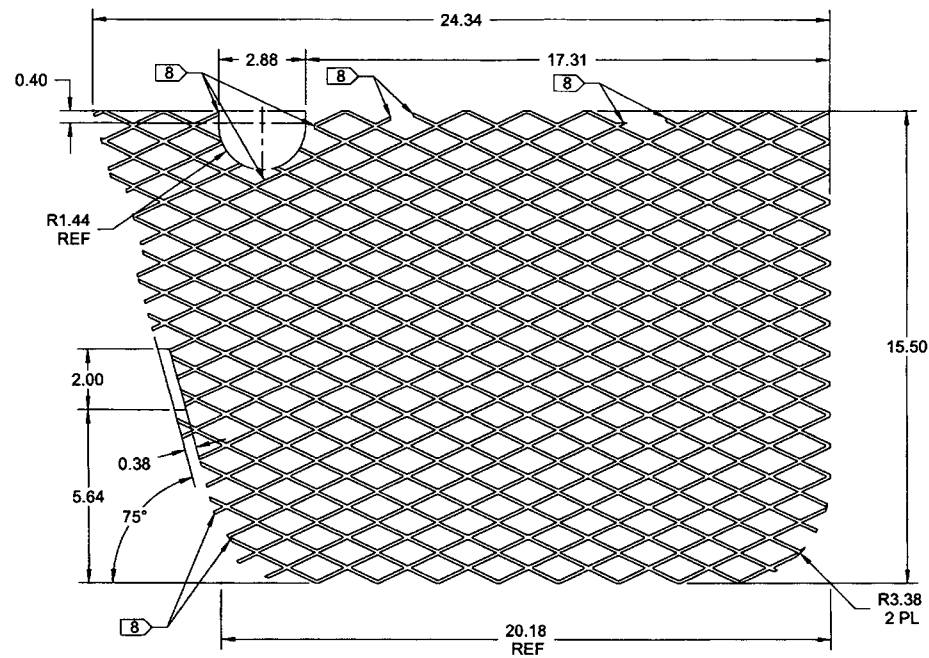
- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

9 D4020-5 MESH (350 BASKET LONG, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010-03-12
MD

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



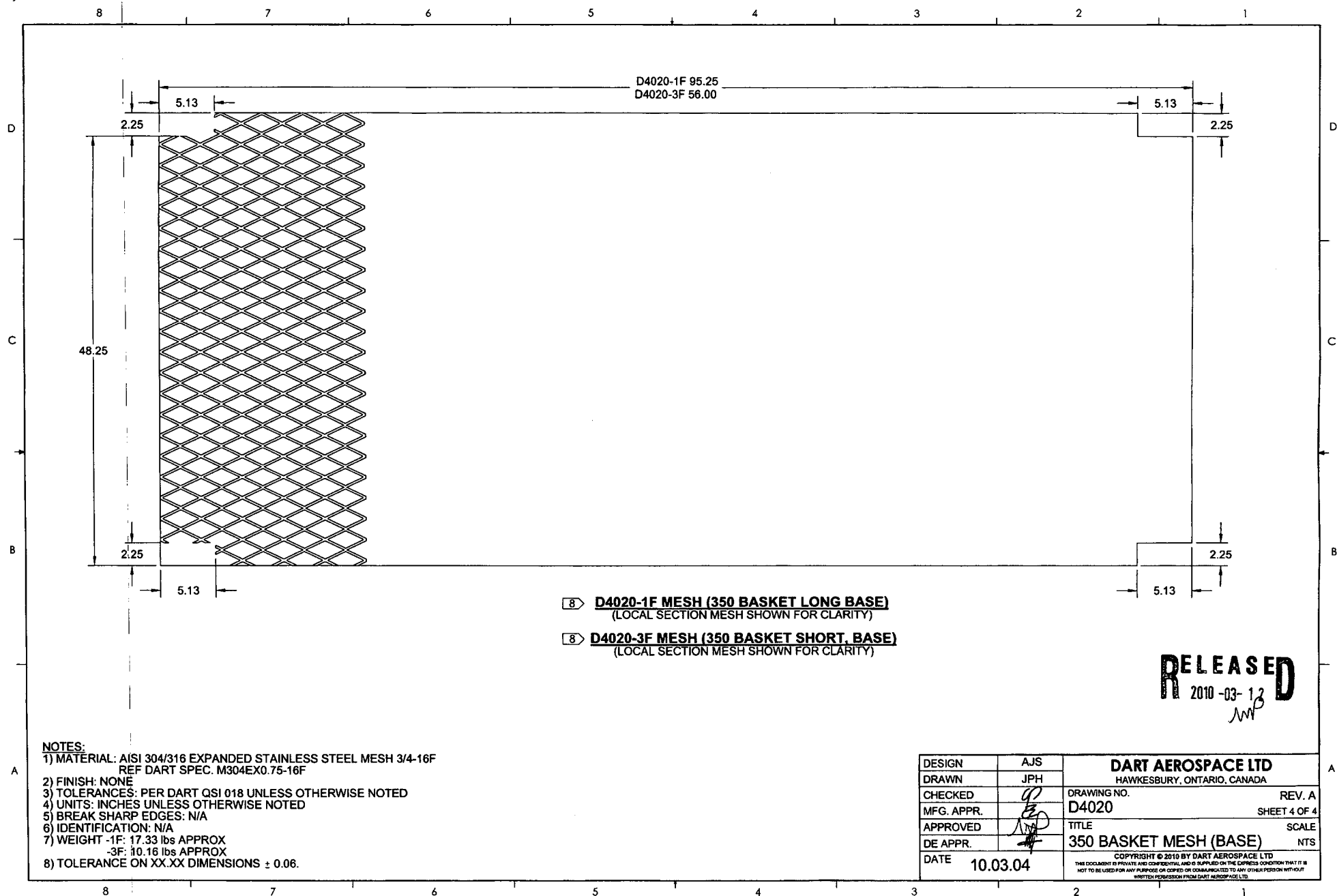
9 D4020-11 END MESH, BASKET

NOTES:

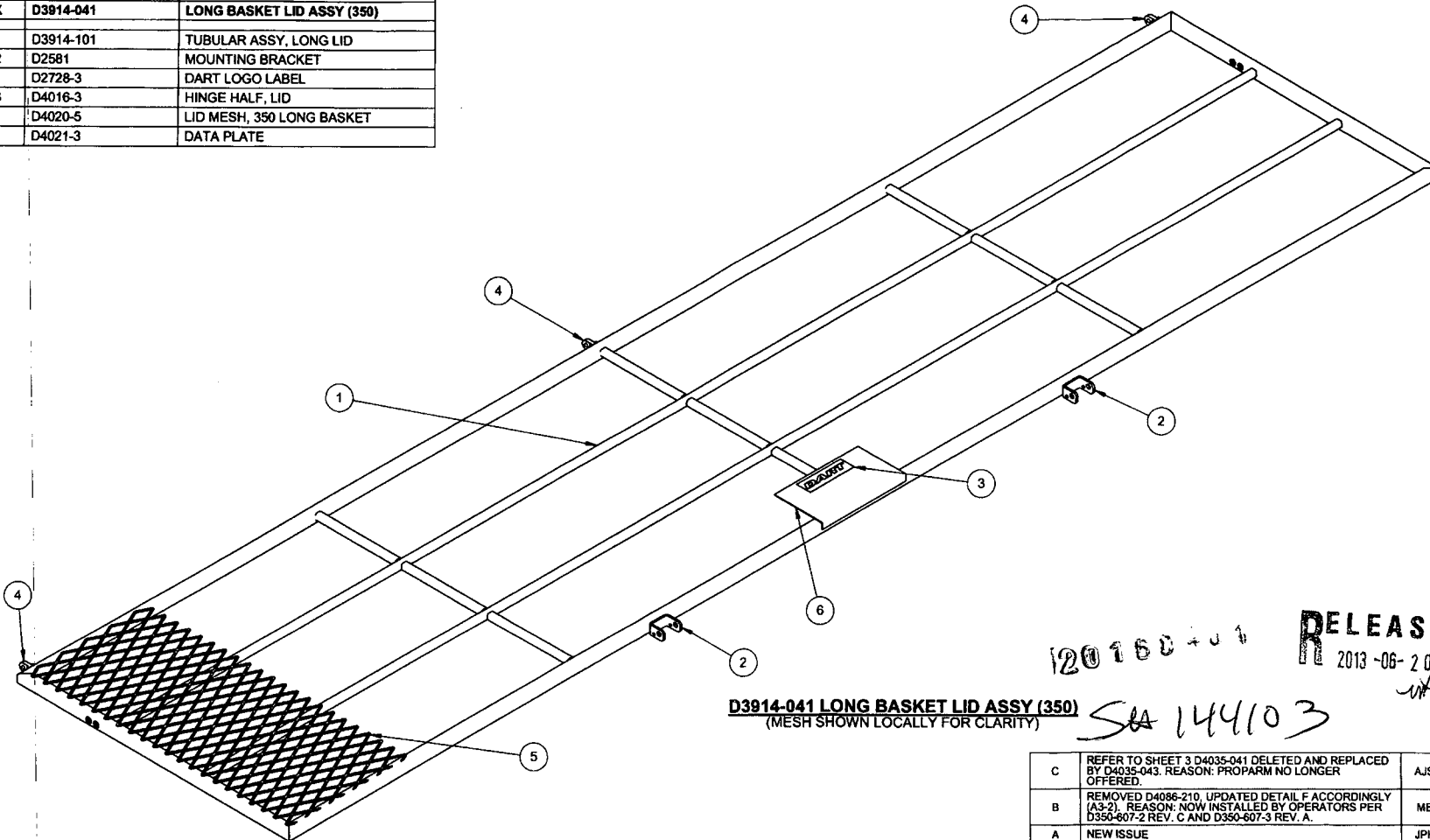
- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
JMP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



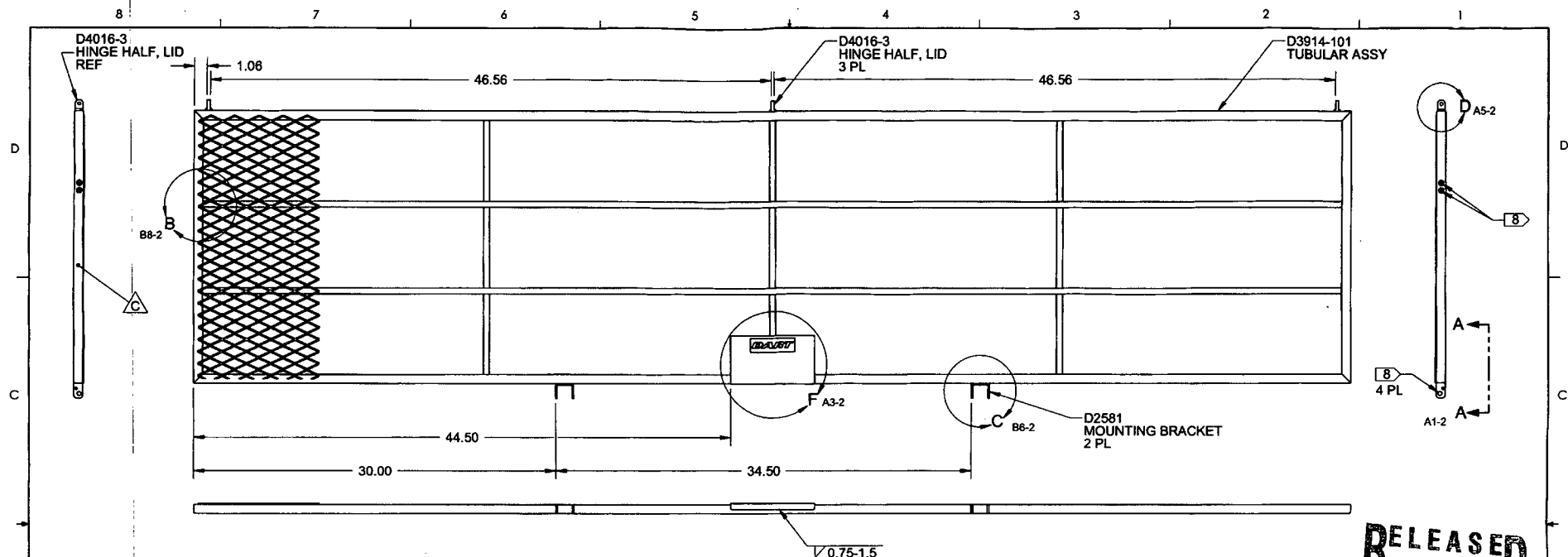
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
5	1	D4020-5	LID MESH, 350 LONG BASKET
6	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROFORM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	A.P.		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS	REV. C	
DATE	13.03.13	SHEET 1 OF 4	
		SCALE NTS	

120160-001
RELEASED
2013-06-20
SEA 144103

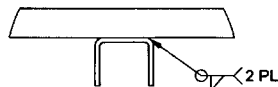


D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

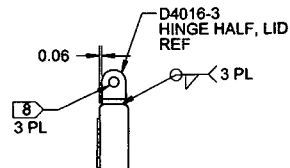
TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4020-5
MESH

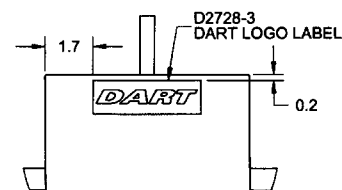
DETAIL B D8-2



DETAIL C C3-2

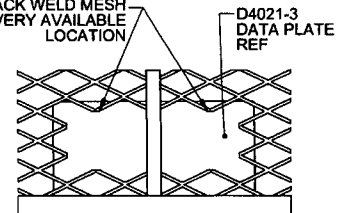


DETAIL D D1-2



DETAIL F C4-2

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



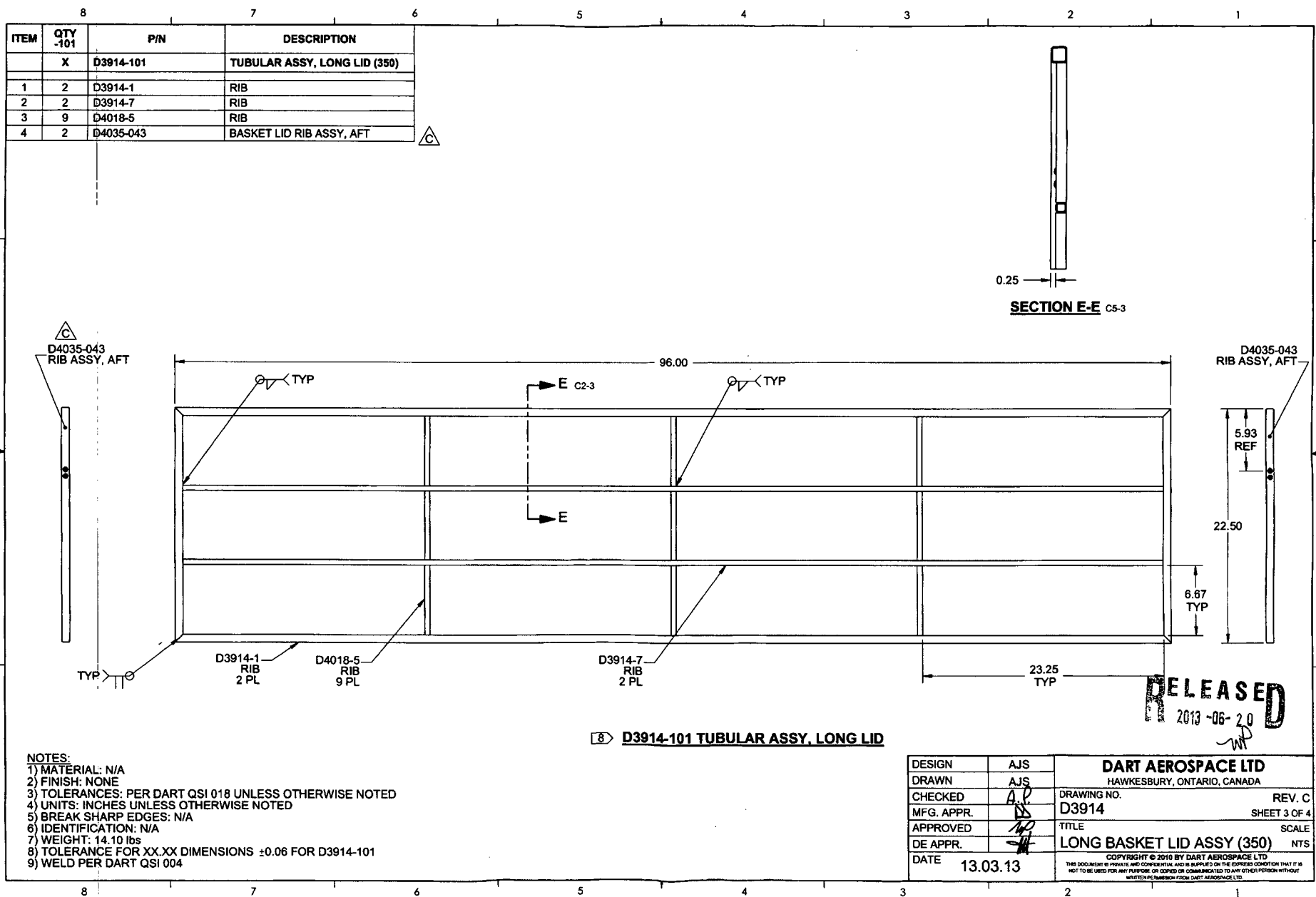
VIEW A-A C1-2

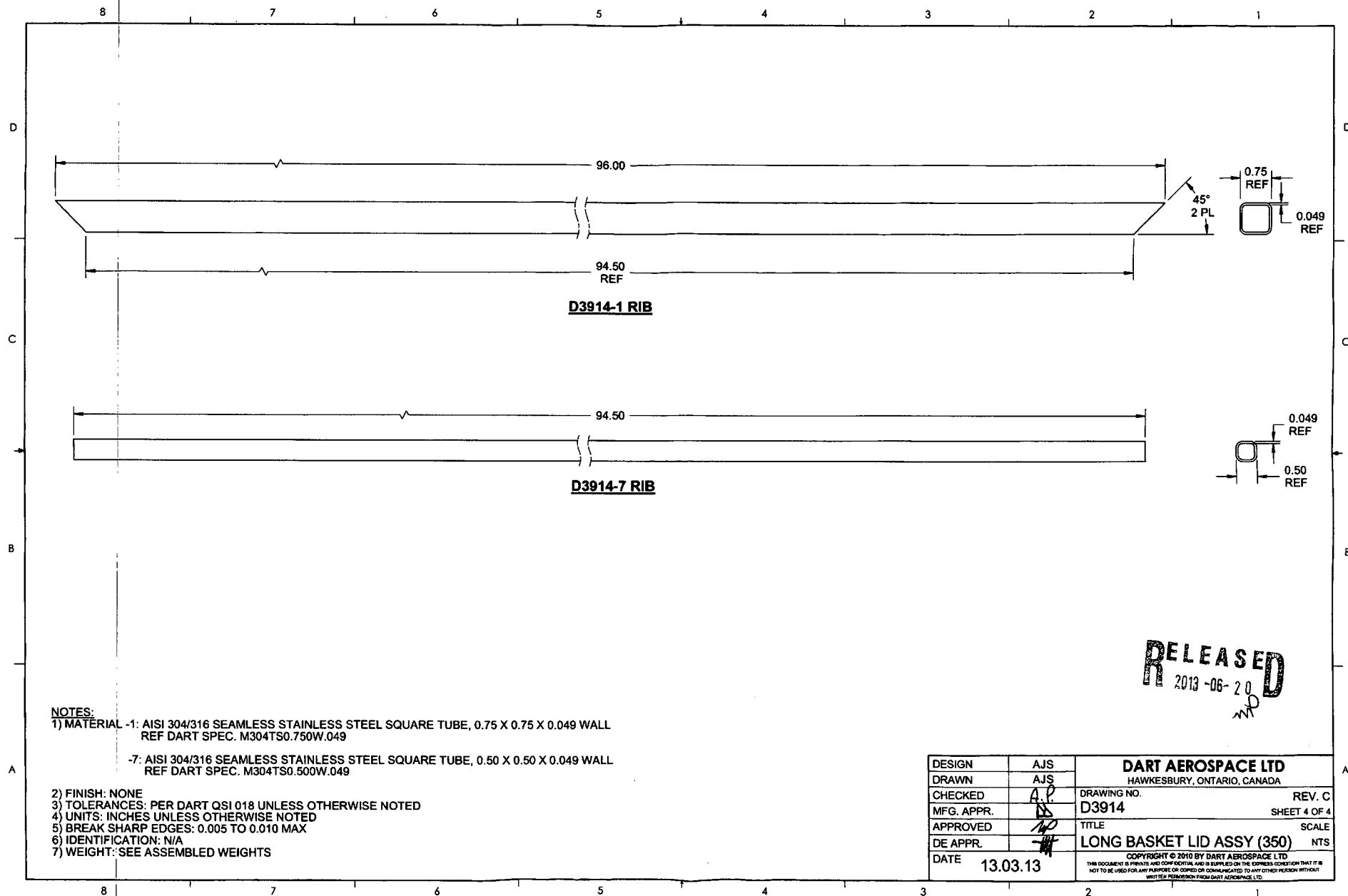
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	JS	D3914	SHEET 2 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	LONG BASKET LID ASSY (350) NTS	
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RELEASED
2013-06-20





RELEASED
2013-06-20
MD

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CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	SS	D3914	SHEET 4 OF 4
APPROVED	MD	TITLE	SCALE
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